

SHIP 78074 June 5

Work Order ID 102637

102637

Page 1

June-05-13 7:47:02 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/05/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

5h3
13.66
NON EMPLOYER

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/RAluminum Rod 125127

123928

3-Grind End Plate flush

13.06.05

Work Order ID 102637

102637

Page 2

June-05-13 7:47:02 AM

Item ID: D350-591-311 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long LH
 Start Date: 6/05/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/05/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							DAS 09 2-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 09 2-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							13-06-05

Work Order ID 102637

June-05-13 7:47:02 AM

102637

Page 4

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step, Long LH
Start Date: 6/05/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/05/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							DAS 09 9-89
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 09 9-89
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							1 p AL 13-6-5

Work Order ID 102637

June-05-13 7:47:02 AM

102637

Page 5

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/05/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch 125814 0.00

230

HandFinish

Hand Finishing

Memo

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

1X of M/F 13/06/05

1 of 13-6-5

1H of 13/06/05

m125620

11' 45" 3200 F
12' 15"

102637

June-05-13 7:47:02 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 6/05/13 **Start Qty:** 1.00 ***1***

Required Date: 6/05/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

250

Memo

0.00

Packaging

Packaging

QC4- 100% Inspect kits for completeness

0.00

260

Memo

0.00

QC

Quality Control

0.00

270

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: ~~1A~~ 1B31

Work Order ID 102637

102637

Page 7

June-05-13 7:47:02 AM

Item ID: D350-591-311 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step, Long LH
 Start Date: 6/05/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/05/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 13-06-06

MF
13-6-06

Picklist Print

June-05-13 7:47:00 AM

Page 1

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

IPP Rev:D fixe

route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011 Step Modification		Manufactured	No				Each	7.0000		1		02566 39	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PKG		7							
				100205		2							
				95544		5							
D3272-1 Step		Manufactured	No			110	Each	20.0000	1	1		13.06.05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003	B102638	20							
				101147		10							
				101149		10							
D3067-1 End Plate		Manufactured	No			110	Each	127.0000	1	1		13.06.05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		78							
				95515		5							
				98655		73							
				WA003		49							
				67582		2							
				68214		1							
				78608		4							
				79607		1							
				83855		1							
				90178		1							
				90486		3							
				95170		2							
				95930		4							
				96228		30							

Picklist Print

June-05-13 7:47:00 AM

Page 2

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

D3219-1
Plate

Manufactured No

110 Each 382.0000 2 2

13-06-05

Location	Loc Qty	Loc Code
WA	152	
101460	152	
WA003	230	
101847	110	<i>2</i>
101870	60	
73410	12	
77674	6	
89967	2	
96128	40	

D3066-1
Spacer

Manufactured No

180 Each 45.0000 2 2

13-06-05

Location	Loc Qty	Loc Code
WA003	45	
95963	4	
99395	41	<i>2</i>

MS20600-AD4W4
Rivets

Purchased No

180 Each 7,390.0000 16 16

13-06-05

Location	Loc Qty	Loc Code
ST	5000	
125577	5000	
ST311	390	
123900	350	
125406	40	<i>16</i>
ST506	2000	
125654	2000	

D3065-041
Step Leg Assembly Hi

Manufactured No

180 Each 25.0000 1 1

13-06-05

Location	Loc Qty	Loc Code
WA003	25	
79336	1	
99241	24	<i>1</i>

June-05-13 7:47:01 AM

Shop Packet Print

Page 2

Picklist Print

June-05-13 7:47:01 AM

Page 3

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

D3067-1 Manufactured No
End Plate

180 Each 127.0000 1 1

13-06-05

Location	Loc Qty	Loc Code
WA	78	
95515	5	
98655	73	
WA003	49	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95170	2	
95930	4	
96228	30	

AN3-35A
Bolt

Purchased No

250 Each 312.0000

2 1 2 20

Location	Loc Qty	Loc Code
FG	10	
122800	10	
ST352	302	
125211	302	

D3235-1
Mounting Lug

Manufactured No

250 Each 171.0000

2 125211 2 20 13-06-05

Location	Loc Qty	Loc Code
ST470	171	
90002	2	
92286	1	
96415	2	
99256	100	
99406	66	

Shp

99406

June-05-13 7:47:01 AM

Shop Packet Print

Page 3

Picklist Print

June-05-13 7:47:01 AM

Page 4

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

D3278-041

Support Assembly

Manufactured No

250 Each 24.0000

0

① - go



Location

Loc Qty

Loc Code

ST470

24

90706

1

99297

23

Shp

AN960JD416

Washer

NAS1149D0463J

Purchased No

250 Each 0.0000

16

99297

124778

① - go



AN960JD516

Washer

NAS1149D0563J

Purchased No

250 Each 2.0000

4

125807

④ - go



Location

Loc Qty

Loc Code

ST504

2

1069059

2

Shp

AN5-36A

Bolt

Purchased No

250 Each 45.0000

2

② - go



Location

Loc Qty

Loc Code

ST338

1

123525

1

ST517

44

125388

44

Shp

D2618

Bushing

Manufactured No

250 Each 164.0000

2

② - go

13-06-05

Location

Loc Qty

Loc Code

ST013

164

89275

1

97780

124

99529

39

Shp

125388

99529

June-05-13 7:47:01 AM

Shop Packet Print

Page 4

Picklist Print

June-05-13 7:47:01 AM

Page 5

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

D2230-3

Lug

Manufactured No

250 Each 61.0000

4 4 JB

Location	Loc Qty	Loc Code
FG	4	
89045	4	
ST469	57	101450
101450	20	
89782	19	
90514	1	
94957	4	
96117	7	
97815	2	
97903	4	

D2856-400

Abrasion Strip

*** cut (2) at 7.20" (D2856-400-720) ***

Manufactured No

250 f 226.9839

1.2 1.2 JB 13-06-05

Location	Loc Qty	Loc Code
ST408	150.05	
99378	150.05	
ST410	35.46	99378
95159	35.46	
ST415	41.4739	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	

June-05-13 7:47:01 AM

Shop Packet Print

Page 5

Picklist Print

June-05-13 7:47:01 AM

Page 6

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

MS2104213

Nut

Purchased No

250 Each 2,611.0000

2

2 go

3

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

2322

123900

954

124291

1368

124291

AN4-13A

Bolt

Purchased No

250 Each 2,467.0000

8

8 go

13-06-05

Location

Loc Qty

Loc Code

FG

20

122808

20

Return2012

8

122416

8

ST513

601

125388

601

ST514

1838

122993

13

123900

10

m125709

1815

125709

June-05-13 7:47:01 AM

Shop Packet Print

Page 6

Picklist Print

June-05-13 7:47:01 AM

Page 7

Work Order ID: 102637

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/05/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

MS210421L5

Nut

Purchased

No

250

Each

1,903.0000

2

2

JB

125654

Location

Loc Qty

Loc Code

ST314

922

125654

922

ST506

1

123900

1

st507

980

125535

980

MS210421L5

Nut

Purchased

No

250

Each

3,151.0000

8

8

JB

125535

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST314

1000

m125708

1000

st507

1863

125535

1863

ST518

238

124231

238

AN960JD10

Washer

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

4

JB

124392

13-06-05

June-05-13 7:47:01 AM

Shop Packet Print

Page 7

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. -B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

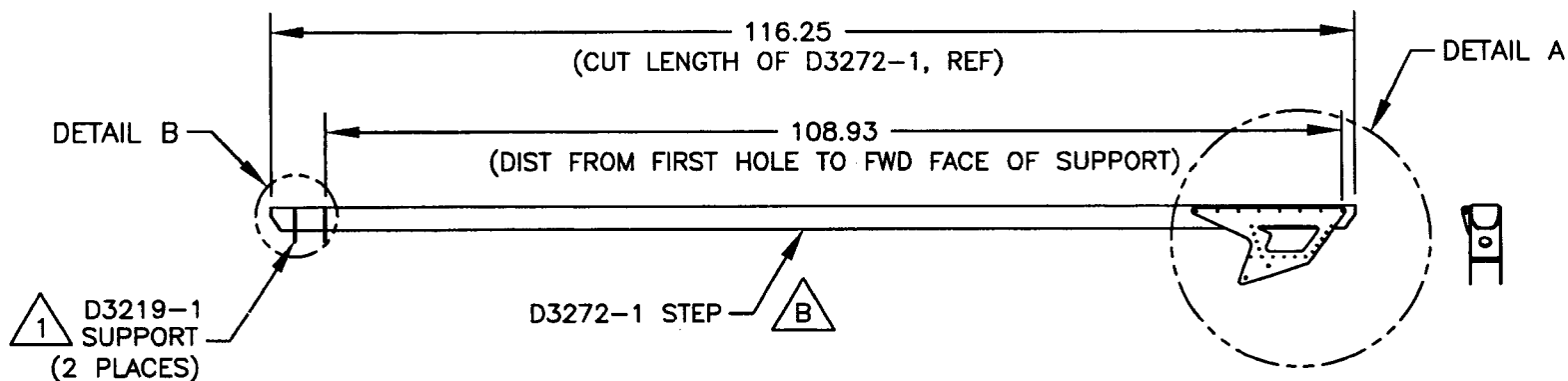
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*1026284***Copyright © 2004 by DART AEROSPACE LTD**

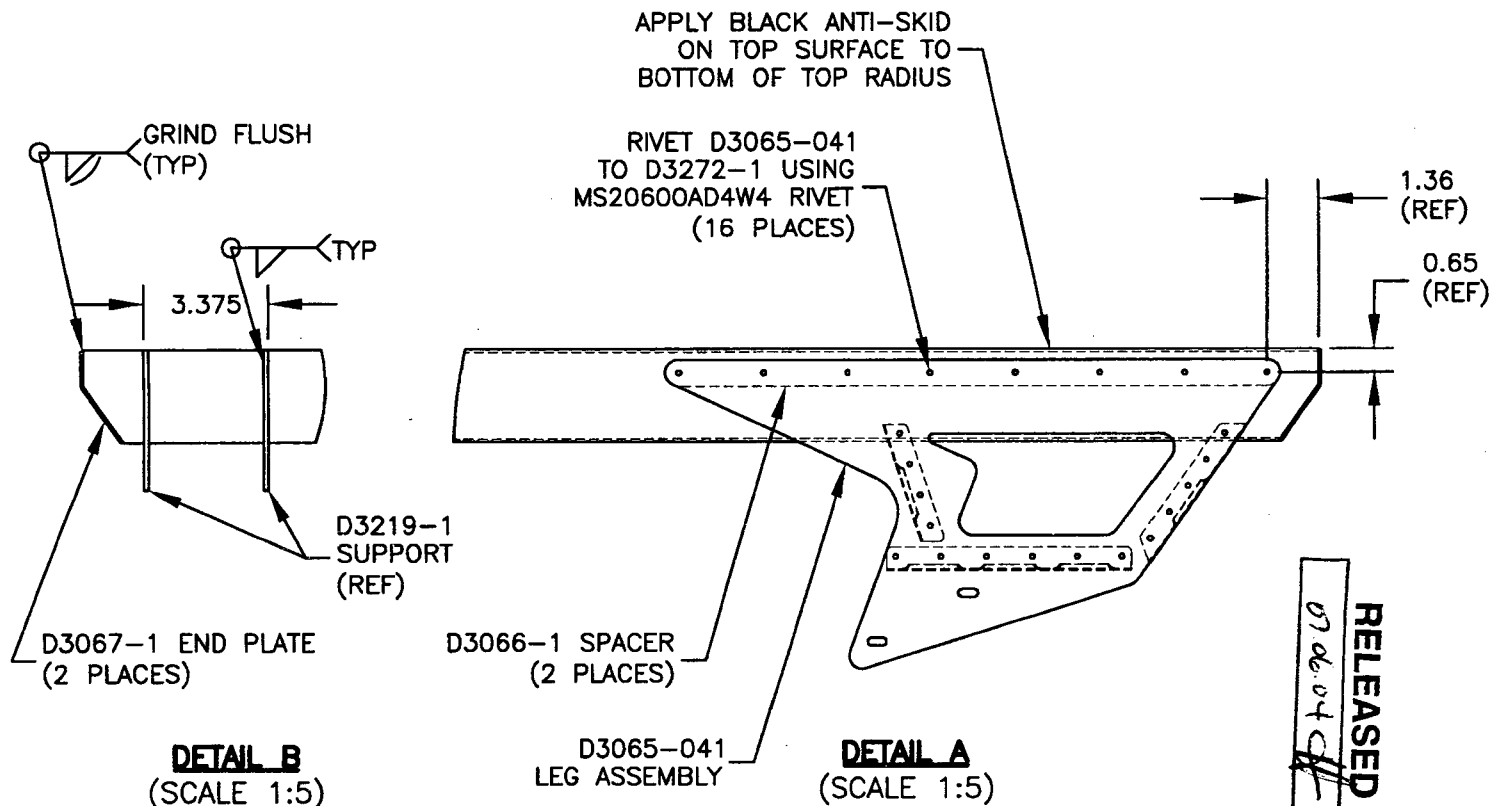
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	q	DRAWN BY	h	DART AEROSPACE LTD
CHECKED	le	APPROVED	h	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

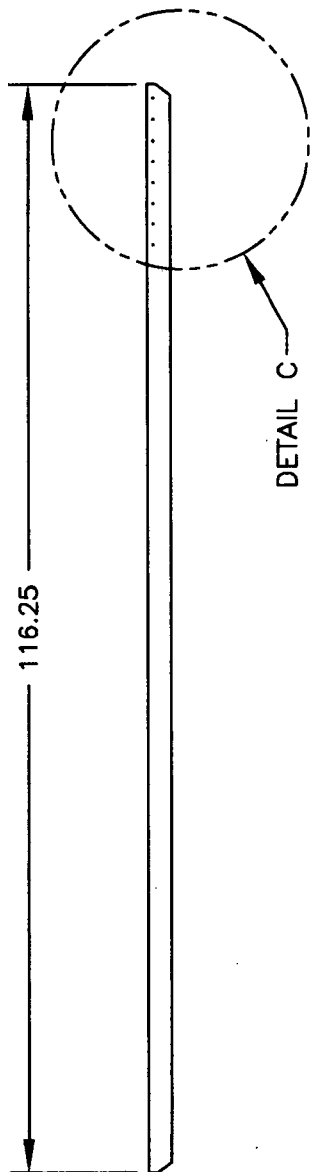




DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

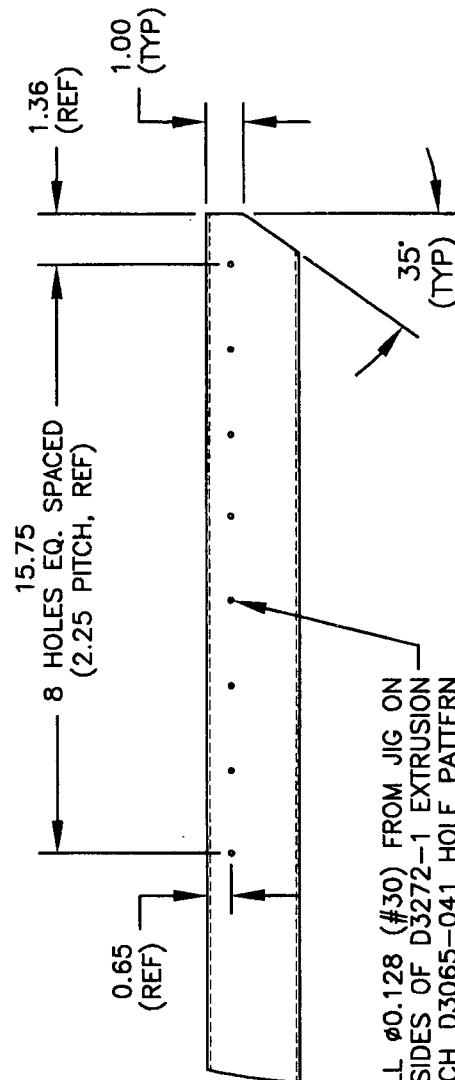
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID 102637

June-05-13 7:47:02 AM

SHIP BODY JUNE 5

102637

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step. Long LH

Stop *NS2*

Start Date: 6/05/13 Start Qty: 1.00 *1*

Required Date: 6/05/13 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CH0001

002

NON EMPLOYER

MJ 13-06-05

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush